

tongued on its lower side to fit a slot, as in the other instance. A bushing plate *R* is mounted on it with a bushing *K* at the forward end. The under side of the block has two narrow bearing surfaces *N* and *M* and it is free to swivel in any direction required by the slightly varying positions of the boss.

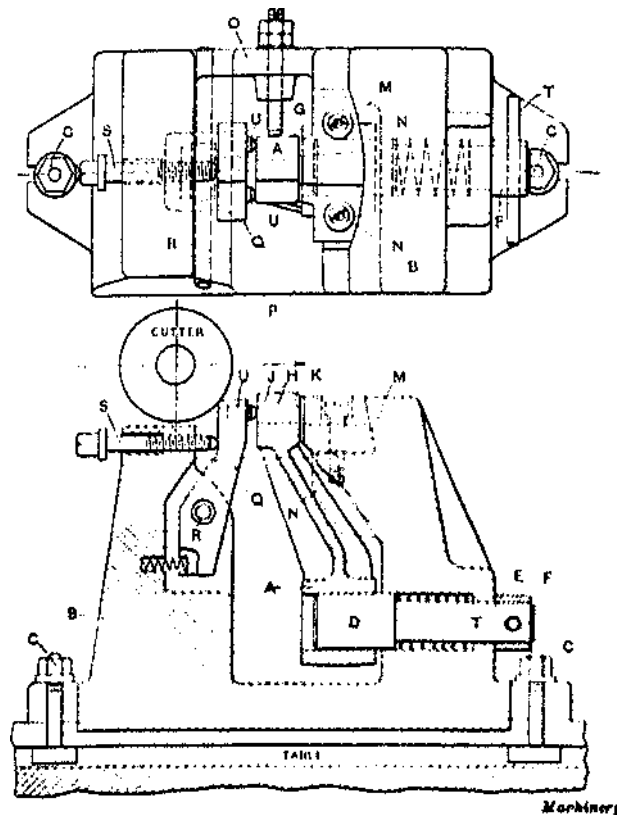


Fig. 4. Milling **Fbctur***
with Floating **CUrap*** and
Locator

The thumb-screw *O* holds It in place afttT It has been located by the operator. The other damp // is then used to hold the piece firmly. A drill jig of this kind is not suited to all classes of work, but it proved satisfactory in this

ntse; the floating
action gives excellent
results when absolute
accuracy in the product is
not required.